

Work Order ID 119866

May-28-14 8:47:47 AM

119866

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Item ID: D4148-1

Revision ID:

Item Name: Crosstube Lug Plate, Fwd

Start Date: 5/28/14 Start Qty: 20.00

Required Date: 5/28/14 Req'd Qty: 20.00

Reference:

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4148	E
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100

0.00

100

Waterjet

FLQW CNC Waterjet

Memo

0.00

Cut as per dwg D4148

Prog Rev: E

Dwg Rev: E

Open Holes to size as per dwg

Deburr as required

DAS 37 9-89 14-05-28

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

DAS 37 9-89 14-05-28

DCA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>119866-2</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Water Jet <input checked="" type="checkbox"/> Engineering <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Quality <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Other <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite <input type="checkbox"/> Supplier <input type="checkbox"/>								
Part No. <u>D4148-1</u>														
NCR No. _____														
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector					
Design	14-05-21	100	1x	Machine malfunction - Jet stayed on when moving between parts - part part gouged.	S 022012 14/06/05	Scrap + destroy No Re-cut, extras cut	fm 14/05/21	DAS 27 01/09 14/11/29	S 14/06/05 022012					
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved														
RC. Machine Malfunction														
FAULT CATEGORY														
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge			<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

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Item ID: D4148-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Lug Plate, Fwd
 Start Date: 5/28/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 5/28/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				14			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				14	14/6/14		DAS 32 9-89
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					14/6/14		14-69

Picklist Print

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Work Order ID: 119866

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Parent Item: D4148-1

D4148-1

Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 5/28/14

Required Date: 5/28/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.10.29 as per revC DD verf:EC
11.03.02 AS PER DWG REV.D DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

157.0000

0.3607

8

M304S11GA

**

304/516 0.125 Sheet

JMM-05-29

Location

Loc Qty

Loc Code

MAT020

157

122521

30

M128254

127

128254.

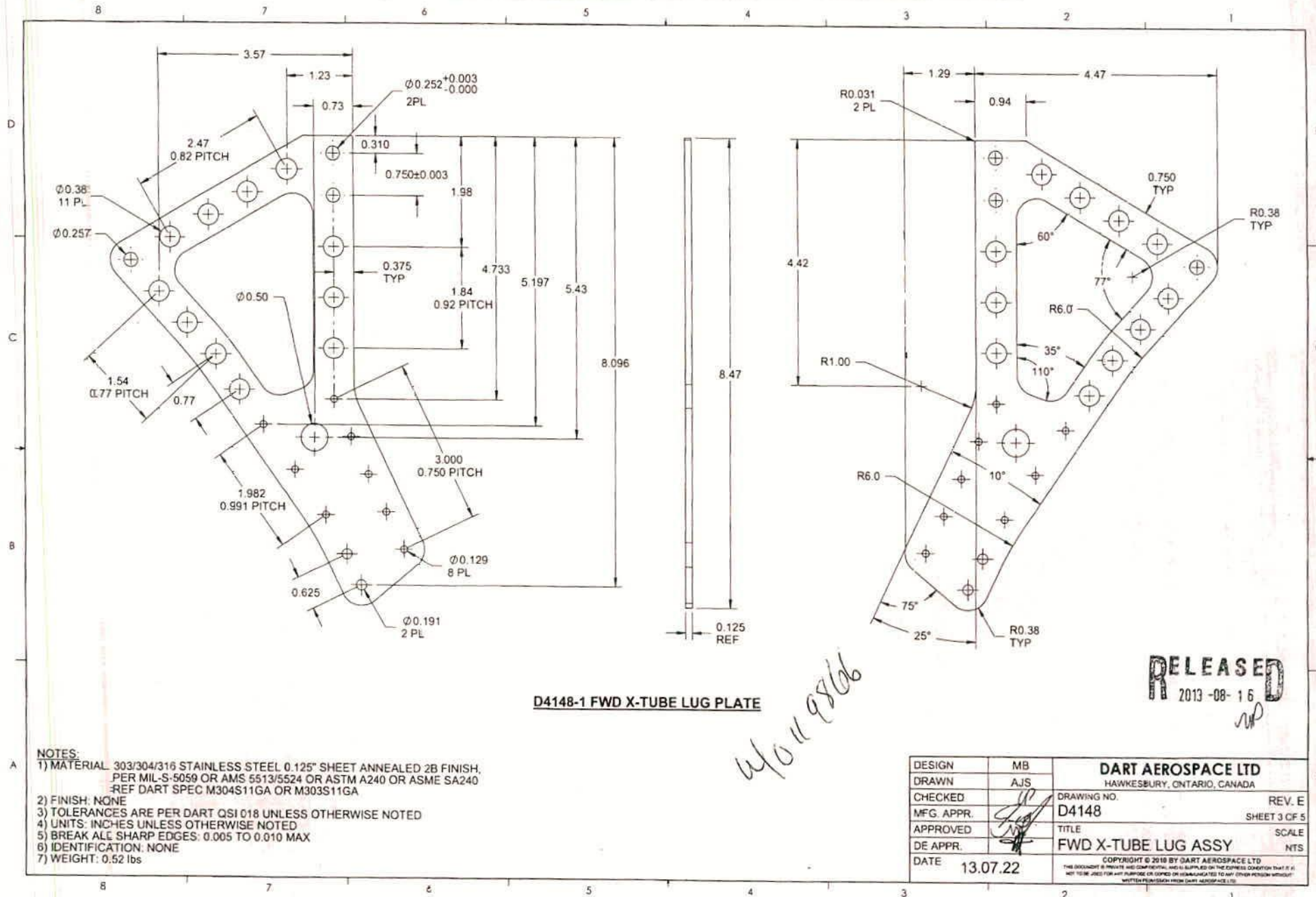
DART AEROSPACE LTD		Work Order: 119806
Description: Fwd Crosstube Lug Plate		Part Number: D4148-1
Inspection Dwg: D4148	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130"	-		✓	Jkmos
Ø0.191	+0.005/-0.001	0.193"	-		✓	
Ø0.38	+0.006/-0.001	0.38"	-		✓	
Ø0.257	+0.006/-0.001	0.258"	-		✓	
Ø0.50	+0.008/-0.001	0.50"	-		✓	
0.94	+/-0.030	0.94"	-		✓	
4.47	+/-0.030	4.47"	-		✓	
0.750	+/-0.010	0.753"	-		✓	
8.47	+/-0.030	8.47"	-		✓	
8.096	+/-0.010	8.096"	-		✓	Jkmos
5.43	+/-0.030	5.43"	-		✓	
5.197	+/-0.010	5.197"	-		✓	
4.733	+/-0.010	4.733"	-		✓	
0.310	+/-0.010	0.312"	-		✓	
0.750	+/-0.010	0.754"	-		✓	
0.375	+/-0.010	0.378"	-		✓	
1.84	+/-0.030	1.84"	-		✓	
0.92	+/-0.030	0.92"	-		✓	
3.000	+/-0.010	3.005"	-		✓	
0.750	+/-0.010	0.753"	-		✓	
0.625	+/-0.010	0.628"	-		✓	
1.982	+/-0.010	1.982"	-		✓	
0.991	+/-0.010	0.991"	-		✓	
0.77	+/-0.030	0.77"	-		✓	
1.54	+/-0.030	1.54"	-		✓	
2.47	+/-0.030	2.47"	-		✓	
0.82	+/-0.030	0.82"	-		✓	
3.57	+/-0.030	3.57"	-		✓	
1.23	+/-0.030	1.23"	-		✓	
0.73	+/-0.030	0.73"	-		✓	
0.125	+/-0.010	0.116"	-		✓	
Ø0.252	+0.003/-0.000	0.254"	-		✓	

Measured by: DAS 37 Jim	Audited by: 123	Preliminary Approval:
Date: 14.05.28	Date: 14/6/16	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.10.08	Dwg Rev updated	KJ	
C	10.11.05	Dimensions updated per Dwg Rev C	KJ	
D	11.03.08	Dwg Rev updated	KJ	
E	12.02.01	Dimensions updated per Dwg Rev D	KJ	
F	13.11.26	Dwg Rev updated	KJ	



D4148-1 FWD X-TUBE LUG PLATE

RELEASED
2013-08-16
np

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

4/01/98/66

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4148	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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